

BLUE

Date: Monday, 17/11/2008 1:53:28 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: 206L /407 STEP ASSY, RH		
Job Number	: 43490A			Part Number	: D2724042		
Estimate Number	: 11703			Drawing Number	: D2724 REV C		
P.O. Number	:			Project Number	:		
This Issue	: 17/11/2008	S.O. No.	:	Drawing Revision	: C		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: LARGE FAB ASSY	Due Date	<i>Shp</i>	Qty:	4
Previous Run	: 39838A			02/02/2009	Um:	Each	
Written By	:						
Checked & Approved By	<u>JUL 08.11.17</u>						
Comment	: Est Rev:E As Per Ecn 766 06-01-06 JLM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D2622120C	Step Extrusion	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Qty Part # Description Batch: 1 D2622-120C Extrusion <i>B42155</i>	
		Check Material for any Dents or Defects	<i>SAD 08-12-29</i> ④
2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
		Comment: LARGE FABRICATION RESOURCE 1	
		Cut D2724-2 using D2622 extrusion as per Dwg D2724 Deburr and bevel ends for welding	<i>SAD 08-12-29</i> ④
3.0	D2734	Step End Plate	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) 206 Step Endplate Pick: Qty Part Number Description Batch 2 D2734 End Cap <i>339179</i>	<i>SH 08-12-30</i> 4
4.0	D34581	Step Mounting Plate	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Qty Part Number Description Batch 2 D3458-1 Plate <i>B43085</i>	<i>SH 08-12-30</i> 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 D34583 Step Mounting Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number
2 D3458-3

Description:
Batch
Plate

343086

H 08.12.30

4

6.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld end cap and lugs as per Dwg D2724 using Jig DT followed by Jig
DT (One End Only)
A/R AL ROD Batch: M108037

Grind end cap welds flush

H 08.12.30

4

H 08.12.30

4

7.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

JF 08.12.30

4

8.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

6.12.30 (1) R14

4

9.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

(P) 08.12.30

4

10.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

K 08.12.30

4

11.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Inspect for foreign object per QSI 024

P 09.1.5

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 43490A

Part Number: D2724042

Job Number:



Seq. #:	Machine Or Operation:	Description :
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Weld Remaining end cap as per Dwg D2724 using Jig DT followed by Jig
DT
A/R AL ROD Batch: M108C31

F 09-01-05

Grind end plate flush.

F 09-01-05

12.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

OK 09-01-05

13.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/01/06 (X) OK

14.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

F 09/01/07 (4)

Touch up Alodine

15.0 SPRAY PAINTING SPRAY PAINTING



Comment:

-PRIME B110199
-SPRAY PAINT DELFLEET BLUE B110071
-CLEAR DELFLEET B110161

M 09-01-15 (4)

16.0 QC14 INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

S 09/01/06 (X) OK

17.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



M 110459

Comment: Wing Walk as per Dwg D2724 and QSI 00 5 4.4

A.m 09.01.16 (4)

18.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



(4)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-00-14 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Seq. #: Machine Or Operation:

Description :

19.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: _____

PPP43490 10/01/2008 G

20.0 QC21 FINAL INSPECTION/W/O RELEASE



09/02/08 JH

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-01-29

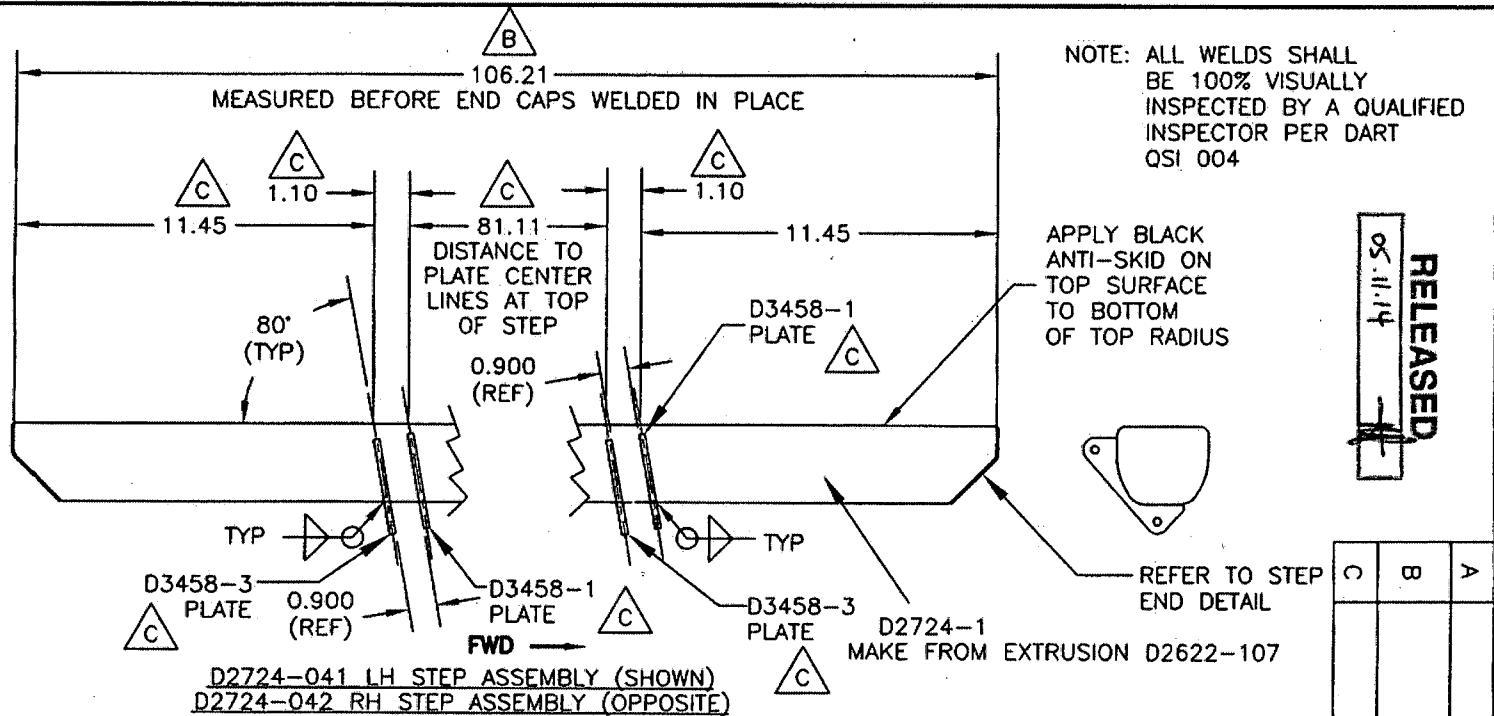
W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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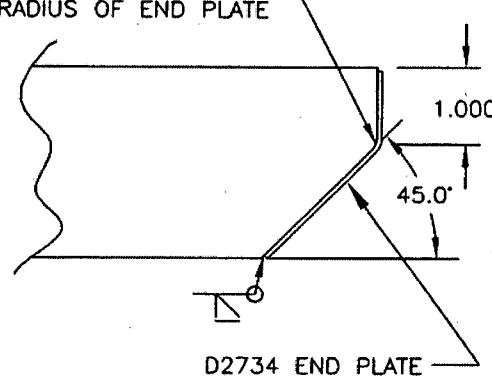


D2721-041/-042 STEP ASSEMBLY PARTS LIST

QTY	QTY	PART NUMBER	DESCRIPTION
-041	-042	D2724-041	LH STEP ASSEMBLY
X	X	D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
NOTICE
TO AMENDMENT
4/3/05
DRAFT

ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE



TYPICAL STEP END DETAIL
NOT TO SCALE



D2724-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN KE	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2724
DATE 05.09.19	REV. A 97.12.04	SHEET 1 OF 1
DATE B 98.10.19	REVISED TOLERANCES	SCALE N/A
DATE C 05.09.19	RE-DESIGN, ADD D3458-1/-3	

DART

RELEASED
05.11.14